

Work Order ID 116506

April-17-14 7:43:42 AM

116506

Page 1

Item ID: D4803-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar Assembly, Sway
Start Date: 4/16/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/01/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 14-04-17 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4803	<u>A</u> <u>B</u> <u>C</u>	<u>14.06.18</u>							

110 0.00 ***110*** 2 FF APR 17 2015
Small Fab Memo 0.00

Small Fab
Memo
ALIGN PILOT HOLES IN D4803-1 WITH PILOT HOLES IN D4869-1 AND
D4806-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
DWG.
REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
DT9976 AS PER DWG.

120 0.00 ***120*** (2) DAS
QC Memo 0.00 38
Quality Control 9-89

APR 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						2	FF		MAY 01 2015
Small Fab	Memo	0.00							
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9976 A/R HYSOL BATCH: <u>1131851</u> USE TECTYL 502C CLASS1, GRADE 2 ANTI-SEIZE COMPOUND ON THREAD AS PER NOTE 12 ON DWG D4803. A/R ANTI SEIZE BATCH: <u>1132203</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						(2)			DAS 38 9-89
QC	Memo	0.00							MAY 06 2015
Quality Control									
150	Identify as per dwg & Stock Location: <u>5128</u>	0.00							
150						DAS 227 9-89			MAY 11 2015
Packaging	Memo	0.00							
Packaging									

P10: P10: 28354

rec'd
inspect

CY MAR 04 2015 2

2X 8015-05-7
(2)

DAS
38
9-89

MAY 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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160	QC21- Final Inspection - Work Order Release	0.00							
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160

QC

Memo

Quality Control

0.00

MLS

MAY 12 2015

MLS

MAY 12 2015

DQA: _____ Date: _____



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Picklist Print

April-17-14 7:43:45 AM

Page 1

2

Work Order ID: 116506

116506

Parent Item: D4803-041

D4803-041

Parent Item Name: Bar Assembly, Sway

Start Date: 4/16/14

Required Date: 5/01/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.01.16 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL20PB5-8 Rivet		Purchased	No				Each	76.0000		8			
HI 20PB5-8									**		FF	APR 17 2015	
* HL 32PB5-8													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST281	129865		66			8			
					M128110		6						
					M128579		60						
				ST284			10						
					M128429		10						
D4803-1 Strut		Manufactured	No				Each	0.0000		2			
D4803-1									**	1	FF	APR 17 2015	
D4806-1 Clevis		Manufactured	No				Each	2.0000		2			
D4806-1									**		FF	APR 17 2015	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST123	121453		2			2			
					112026		2			1			
						B	117318						
D4806-3 Stud		Manufactured	No				Each	3.0000		2			
D4806-3									**		FF	APR 17 2015	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST123	117319		3			2			
					115957		3						

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

April-17-14 7:43:45 AM

Work Order ID: 116506

116506

Parent Item: D4803-041

D4803-041

Parent Item Name: Bar Assembly, Sway

Start Date: 4/16/14

Required Date: 5/01/14

Start Qty: 2.00

Required Qty: 2.00

D4869-1 Manufactured No

Each 2.0000 2

D4869-1

End Fitting, Eye

**

FF

APR 17 2015

Location

Loc Qty

Loc Code

ST131 123304
116167

2
2

2

HL86-5 Purchased No

Each 133.0000

HI 86-5

Collar

**

FF

APR 17 2015

Location

Loc Qty

Loc Code

ST280 129864
M128110
ST284
M128228

33
33
100
100

2

NAS509-6C Purchased No

Each 19.0000

NAS509-6C

Nut

**

FF

APR 17 2015

Location

Loc Qty

Loc Code

ST276
M128110
M128429

19
9
10

2

DQA: _____ Date: _____



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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28354**

Purchase Order Date 5/4/2015

PO Print Date 5/7/2015

Page Number 4 of 5

Order From :

VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO KOC 2E0
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

10	121497	D4882-041	5/8/2015	3.00	\$4.00	\$12.00
			Yes			
			5/8/2015			
	LASER MARKED					

Line Total: \$12.00

11	123330	D4882-042	5/8/2015	4.00	\$4.00	\$16.00
			Yes			
			5/8/2015			
	LASER MARKED					

Line Total: \$16.00

12	116506	D4803-041	5/8/2015	2.00	\$4.00	\$8.00
			Yes			
			5/8/2015			
	LASER MARKED					

Line Total: \$8.00

SP15-05-7

Note:

5/7/2015



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE May 6, 2015

P.O NUMBER PO28354

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4834-42 LEG ASSEMBLY	4	ALL ITEMS HAVE BEEN LASER MARKED
D4866-042 LEG ASSEMBLY	3	
D4868-042 LEG ASSEMBLY	4	
D4878-042 LEG ASSEMBLY	3	
D4879-041 LEG ASSEMBLY	2	
D4880-041 LEG ASSEMBLY	3	
D4880-042 LEG ASSEMBLY	1	
D4881-041 LEG ASSEMBLY	3	
D4881-042 LEG ASSEMBLY	1	
D4882-041 LEG ASSEMBLY	3	
D4882-042 LEG ASSEMBLY	4	
D4803-041 LEG ASSEMBLY	2	

SP15-057



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

Invoice

Number: 7763

Date: May 06, 2015

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
28354		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4834-042	4.00	4.00	✓	16.00
Laser Metal Marking, D4866-042	3.00	4.00	✓	12.00
Laser Metal Marking, D4868-042	4.00	4.00	✓	16.00
Laser Metal Marking, D4878-042	3.00	4.00	✓	12.00
Laser Metal Marking, D4879-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4880-041	3.00	4.00	✓	12.00
Laser Metal Marking, D4880-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4881-041	3.00	4.00	✓	12.00
Laser Metal Marking, D4881-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4882-041	3.00	4.00	✓	12.00
Laser Metal Marking, D4882-042	4.00	4.00	✓	16.00
Laser Metal Marking, D4803-041	2.00	4.00	✓	8.00
Sub-Total				\$132.00
13.00% on 132.00				17.16
Total				\$149.16

*Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.*

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You